

Work Order ID 60901

Monday, July 26, 2010 2:12:18 PM



Page 1

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 7/26/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-7-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9467	Rev A								
IIN D206-642	Rev N								
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-511	CHG004							
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

S 10/08/12

10/8/11 (12) SD 3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		8/06/12		(13)			
130 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP K642-511 Location: PK	0.00 0.00		Rev B		10/6/12	SL	3x	
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/08/13 MF 10-8-12

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Table 1. Demographic characteristics of study population

	N (%)
Age group (years)	
<60	78 (9.3)
60-69	102 (12.2)
70-79	125 (15.0)
≥80	195 (23.4)
Total	840 (100)
Gender	
Male	400 (47.6)
Female	440 (52.4)
Total	840 (100)
Ethnicity	
Chinese	102 (12.2)
Malay	125 (15.0)
Indian	195 (23.4)
Others	618 (73.8)
Total	840 (100)
Marital status	
Single	102 (12.2)
Married	125 (15.0)
Widowed	195 (23.4)
Divorced	618 (73.8)
Total	840 (100)
Education level	
Primary school or below	102 (12.2)
Secondary school	125 (15.0)
Tertiary school	195 (23.4)
Postgraduate	618 (73.8)
Total	840 (100)
Occupation	
Unemployed	102 (12.2)
Retired	125 (15.0)
Self-employed	195 (23.4)
Employed	618 (73.8)
Total	840 (100)

Required Date: 8/2/2010

Required Qty: 3.00

Comments: IPP Rev:A 07.06.05 new issue EC
IPP Rev.B 08.02.05 , Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A 		Purchased	No			110	Each	80.0000	3	9		10/8/12 SP	
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST353				80					
				111724				1					
				112489				49		9			
				114523				30					
AN3C36A 		Purchased	No			110	Each	41.0000	9	27		10/8/12 SP	
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST353				41					
				101261				4					
				106541				6		6			
				114653				31					
AN3C41A 		Purchased	No			110	Each	117.0000	8	24		10/8/12 SP	3x
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				4					
				103324				4					
				ST354				113					
				108084				8		8			
				112829				5		5			
				114443				100		11			

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Work Order ID: 60901

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

110

Each

419.0000

12

36



Bolt



10/8/12 SP

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

415

113121

215

115016

200

36

AN5C11A

Purchased

No

110

Each

236.0000

8

24



Bolt



10/8/12 SP

Location

Loc Qty

Loc Code

FG

4

104817

4

ST338

232

114443

62

114455

70

114523

100

24

AN5C12A

Purchased

No

110

Each

88.0000

4

12



10/8/12 SP

36

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

86

113121

86

12

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Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN5C13A

Purchased

No

110

Each

106.0000

4

12



10/8/12 sl

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

104

107615

1

111648

3

113121

50

114615

50

1
2

AN5C15A

Purchased

No

110

Each

93.0000

1

3



10/8/12 sl

Location

Loc Qty

Loc Code

ST339

93

111819

93

3
6

AN5C32A

Purchased

No

110

Each

99.0000

2



10/8/12 sl @

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

95

110155

4

111808

41

113164

50

4
2

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN5C34A

Purchased

No

110

Each

112.0000

2

6

10/8/12 sf



Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

110

111648

50

112454

60

AN5C35A

Purchased

No

110

Each

97.0000

1

10/8/12 sf



Location

Loc Qty

Loc Code

ST340

97

107551

1

108084

50

108407

46

AN960C10L

NAS1149C0332

Purchased

No

110

Each

29.0000

24

72

1115000 10/8/12 sf 30



washer

Location

Loc Qty

Loc Code

ST245

29

107534

29

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W/O:		WORK ORDER CHANGES					
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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN960C416L

Purchased

No

110

Each

820.0000

24

72

10/8/12 sl



WASHER

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

776

106785

38

107008

10

112794

287

112828

400

69220

41

72

AN960C516L

NAS1149C0532

Purchased

No

110

Each

6.0000

8

24

M114348 10/8/11 sl



WASHER

Location

Loc Qty

Loc Code

ST347

6

111916

6

110

Each

1.0000

1

3

61048 10/8/11 sl 30

D206-648-013

CHG 022

Manufactured

No



GHW Modification

Location

Loc Qty

Loc Code

FG120

1

59234

1

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Work Order ID: 60901

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2652

Manufactured No

110

Each

249.0000

16

48



Bushing



10/8/10 SP

Location

Loc Qty

Loc Code

FG

44

31985

44

ST021

205

58176

42

59109

163

D2712

Manufactured No

110

Each

203.0000

10

48



Set Screw



10/8/11 SP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST022

153

16400

20

34628

10

50415

123

D2932-1

Manufactured No

110

Each

8.0000

1

3



Saddle LH Out, 206



10/8/11 SP (30)

Location

Loc Qty

Loc Code

ST421

4

52590

1

53327

3

ST428

4

59936

4

3

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 60901

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2933-1

Manufactured No

110 Each

7.0000

1

3



Saddle LH In, 206



① B60904 10/8/11 SP

Location

Loc Qty

Loc Code

ST421

3

53328

3

ST428

4

59937

4

Manufactured No

110 Each

70.0000

2

D2934



Saddle Spacer



6 10/8/11 SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST031

64

59641

64

Manufactured No

110 Each

56.0000

2

D2935



Saddle Spacer



6 10/8/11 SP (30)

Location

Loc Qty

Loc Code

ST028

45

59642

45

ST031

11

50211

11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 60901

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2938-1

Manufactured No

110

Each

5.0000

1

3



Saddle LH Out, 206



B60901 10/8/11 sf

Location

Loc Qty

Loc Code

ST421

3

53331

3

ST428A

2

58532

2

D2939-1

Manufactured No

110

Each

9.0000

1

3



Saddle LH In, 206



10/8/11 sf

Location

Loc Qty

Loc Code

ST421

3

53333

3

ST428A

6

58267

2

58534

4

D3396-3

Manufactured No

110

Each

43.0000

2

6



Spacer



3 10/8/11 sf 3x

Location

Loc Qty

Loc Code

FG

10

26772

10

ST055

33

36336

2

58680

31

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 60901

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D3407-043

Manufactured No

110

Each

38.0000

1

3



Tow Ring



10/8/11 sl

Location

Loc Qty

Loc Code

ST464

38

50176

6

50387

20

53351

12

2

D3456-1

Manufactured No

110

Each

53.0000

1

3



Washer



10/8/11 sl

Location

Loc Qty

Loc Code

ST058

53

54692

53

3

D3457-1

Manufactured No

110

Each

63.0000

2

6



Washer



10/8/11 sl (3x)

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

53

45913

2

52981

51

6

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 60901

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D3672-1

Manufactured No

110 Each

1,015.000 24



Phenolic Washer



72
10/8/11 SP

Location

Loc Qty

Loc Code

ST077

997

51674

5

52505

992

ST117

18

34470

18

5
67

D3672-3

Manufactured No

110 Each

750.0000 24



Phenolic Washer



72
10/8/11 SP

Location

Loc Qty

Loc Code

ST077

750

57704

750

D3672-7

Manufactured No

110 Each

676.0000 24



Phenolic Washer



72
10/8/11 SP

Location

Loc Qty

Loc Code

ST077

676

53237

676

MS21043-3

Purchased No

110 Each

2,985.000 20



Nut



72
60
10/8/11 SP 3x

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2909

107280

4

112314

2905

60

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Work Order ID: 60901



Parent Item: K642-511



Parent Item Name: saddle kit 642-511

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

110

Each

1,220.000

13

39



10/8/11 SP

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1180

112492

25

113069

8

114348

347

114523

500

114784

300

39

MS21043-5

Purchased

No

110

Each

612.0000

4

12



10/8/11 SP

300

Nut

Location

Loc Qty

Loc Code

ST301

612

111819

112

112314

500

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			AN3C4A	* BOLT ⁽¹⁾
5A			2			AN960C10L	* WASHER ⁽¹⁾
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4				AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C8A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET ⁽¹⁾
23A			1	1		D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET ⁽¹⁾
24A			1	1		D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET ⁽¹⁾
25A			1	1		D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET ⁽¹⁾
26A			78	78		AN3C4A	* BOLT ⁽¹⁾
26B			78	78		AN960C10L	* WASHER ⁽¹⁾
26C			78			ALS7-1032-130 (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	* INSERT ⁽¹⁾
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE

(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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